

Split - 1
Work Order ID 138953 - 1

138953

Page 1

Friday, November 13, 2015 11:36:53 AM

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle

4.00

Start Date: 11/30/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: NOV 17 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3500

C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.07

Program Batch No. 138953 Double check by JFC 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
No 2 per Folio FA641and inspect per attached Dimension Sheets3-Machine
Step No 3 per Folio FA641 and inspect p

4

4

DAS
44
9-89

15/12/09

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

4

4

DAS
44
9-89

15/12/09

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.01

4

15/12-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (Q51042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Friday, November 13, 2015 11:36:53 AM

Page 2

Quality Control

4 ⊕ 15-12-10 11

H ϕ 15-12-10 DAS 34 0.89

4

DAS
38
9-89

DEC 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Work Order ID 138953

138953

Page 3

Friday, November 13, 2015 11:36:53 AM

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 11/30/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.03							
Quality Control									

15/12/10 ST

MUS DEC 11 2015

DEC 11 2015

MUS

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																			
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Large Fab ☐	Composite ☐	Supplier ☐																				
Date : _____	Step #: _____	QTY Effective : _____			MRB (Q51042) Approval																	
Description Work Order Deviation		Disposition			Completed By																	
					Lead hand / Supervisor Approval Verification																	
					QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : _____																						

Picklist Print

Friday, November 13, 2015 11:36:53 AM

Page 1

Work Order ID: 138953

138953

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	12.0000	1	20			
D6102-013									**				
Saddle Billet													

DAS
44
9-89

15/12/07

Location

Loc Qty

Loc Code

MAT040

12

131195

12

138664

20

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval					
Description Work Order Deviation				Disposition				Completed By				
								Lead hand / Supervisor Approval Verification				
												QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY										
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐							
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐							
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐							
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐							
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐							
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐							
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____										
Misidentified ☐	Past Due ☐											

DART AEROSPACE LTD				Work Order: 138953	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490		.485	.485	.485	.485	
B	1.175	1.185		1.180	1.180	1.180	1.180	
C	3.145	3.155		3.150	3.150	3.150	3.150	
D	1.175	1.185		1.180	1.180	1.180	1.180	
E	0.365	0.385		.377	.377	.377	.377	
F	0.490	0.510		.498	.498	.498	.498	
H	R0.515	R0.535		.525	.525	.525	.525	
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.5875	1.584	1.583	1.584	
J	0.240	0.260		.248	.249	.250	.250	
K	0.490	0.510		.499	.499	.500	.499	
L	3.590	3.650		3.620	3.620	3.620	3.620	
M	0.315	0.322		.316	.316	.316	.316	
N	0.256	0.262		.258	.258	.258	.258	
O	6.500	6.520		6.506	6.507	6.507	6.508	
P	5.990	6.010		5.994	5.997	5.997	5.998	
Q	2.820	2.830		2.825	2.825	2.825	2.825	
R	2.495	2.505		2.500	2.500	2.500	2.500	
S	2.245	2.255		2.250	2.250	2.250	2.250	
T	1.120	1.130		1.125	1.125	1.125	1.125	
U	0.540	0.560		.548	.548	.549	.548	
V	0.793	0.803		.798	.798	.798	.798	
W	R.240	R.260		.250	.250	.250	.250	
X	0.040	0.060		.050	.050	.050	.050	
Y	0.100	0.120		.105	.105	.105	.105	
AA	R1.125	R1.145		1.133	1.1315	1.132	1.132	
AB	R.490	R.510		.500	.500	.500	.500	
AC	0.615	0.635		.625	.625	.625	.625	
AD	0.240	0.260		.257	.257	.257	.256	
AE	1.810	1.830		1.821	1.820	1.821	1.821	
AF	0.240	0.260		.251	.249	.249	.250	
AG	0.140	0.160		.151	.149	.149	.149	
AH	0.140	0.160		.151	.152	.150	.152	
AI	0.140	0.160		.153	.153	.153	.151	

DAS Accept/Reject

Measured by: 44	Date: 15/12/09
Audited by: SL	Date: 15-12-9
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 138953	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

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A	0.483	0.490						
B	1.175	1.185						
C	3.145	3.155						
D	1.175	1.185						
E	0.365	0.385						
F	0.490	0.510						
H	R0.515	R0.535						
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595						
J	0.240	0.260						
K	0.490	0.510						
L	3.590	3.650						
M	0.315	0.322						
N	0.256	0.262						
O	6.500	6.520						
P	5.990	6.010						
Q	2.820	2.830						
R	2.495	2.505						
S	2.245	2.255						
T	1.120	1.130						
U	0.540	0.560						
V	0.793	0.803						
W	R.240	R.260						
X	0.040	0.060						
Y	0.100	0.120						
AA	R1.125	R1.145						
AB	R.490	R.510						
AC	0.615	0.635						
AD	0.240	0.260						
AE	1.810	1.830						
AF	0.240	0.260						
AG	0.140	0.160						
AH	0.140	0.160						
AI	0.140	0.160						
Accept/Reject								

Measured by:			Date:	
Audited by:			Date:	
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
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DART AEROSPACE LTD		Work Order: 138953
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1

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AB	R.490	R.510						
AC	0.615	0.635						
AD	0.240	0.260						
AE	1.810	1.830						
AF	0.240	0.260						
AG	0.140	0.160						
AH	0.140	0.160						
AI	0.140	0.160						
Accept/Reject								

Measured by:		Date:
Audited by:		Date:
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
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B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order: 138953
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1

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H	R0.515	R0.535						
(Note: Dimension I is 0.015" over flange)								
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Q	2.820	2.830						
R	2.495	2.505						
S	2.245	2.255						
T	1.120	1.130						
U	0.540	0.560						
V	0.793	0.803						
W	R.240	R.260						
X	0.040	0.060						
Y	0.100	0.120						
AA	R1.125	R1.145						
AB	R.490	R.510						
AC	0.615	0.635						
AD	0.240	0.260						
AE	1.810	1.830						
AF	0.240	0.260						
AG	0.140	0.160						
AH	0.140	0.160						
AI	0.140	0.160						
Accept/Reject								

Measured by:	Date:
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

15-11-1

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